

ship Sept 19.

Work Order ID 151239

151239

Page 1

Friday, September 16, 2016 9:04:27 AM

Item ID: D206-642-257

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Standard Wearplates, High Gear 206A/B Fits LH or RH

Start Date: 9/16/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 9/21/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: dem

Date: 16/09/16

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN D206-642

Q

SEP 16 2016

DAS
6
9-89

DAS
21
9-89

1609-16

(2)

100

Document Control

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D206-642-257
CHG001

X2 DAS
27
9-89
SEP 19 2016

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

(2)

PK

DAS
6
9-89
SEP 16 2016

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

X2 DAS
27
9-89
SEP 19 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : ☐			

Work Order ID 151239***151239***

Page 2

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Cust Item ID:

Required Date: 9/21/2016 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-257								
	Location: _____								
	PPP rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

SEP 19 2016

SEP 19 2016

SEP 19 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Friday, September 16, 2016 9:04:27 AM

Page 1

Work Order ID: 151239

151239

Parent Item: D206-642-257

D206-642-257

Parent Item Name: Standard Wearplates, High Gear 206A/B Fits LH or RH

Start Date: 9/16/2016

Required Date: 9/21/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 14.04.24 ECN14-520 DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3537-1

Manufactured

No

Each

96.0000

**

8

PC

DAS
8

D3537-1

Wearpad

DAS
27
9-09

Location

Loc Qty

Loc Code

FG

14

79833

4

88562

10

FP001

81

141922

7

147593

58

148732

16

ST184

1

125911

1

D3537-3

Manufactured

No

Each

44.0000

**

2

PC

DAS
8

D3537-3

Wearpad

DAS
27
9-09

Location

Loc Qty

Loc Code

FG

8

86237

8

FP001

36

141220

5

141921

31

SEP 16 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																			
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Page 2

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151239

Parent Item: D206-642-257

D206-642-257

Parent Item Name: Standard Wearplates, High Gear 206A/B Fits LH or RH

Start Date: 9/16/2016

Required Date: 9/21/2016

Start Qty: 2.00

Required Qty: 2.00

D4956-13 Manufactured No

Each

12.0000

D4956-13

Wearplate Fwd

**

1

2

PC

DAS
6
9-89

Location

Loc Qty

Loc Code

FP002

12

120491

1

127090

11

Each

13.0000

**

1

2

PC

DAS
6
9-89

D4956-21 Manufactured No

D4956-21

Wearplate Center

Location

Loc Qty

Loc Code

FP002

13

130523

13

Each

12.0000

**

1

2

PC

DAS
6
9-89

D4956-33 Manufactured No

D4956-33

Wearplate Aft

Location

Loc Qty

Loc Code

FP002

12

120318

2

123563

10

Each

486.0000

**

44

88

PC

DAS
6
9-89

MS27039C1-08 Purchased No

MS27039C1-08

SCREW

Location

Loc Qty

Loc Code

FP001

324

m124586

60

m134370

55

m135127

209

ST277

162

m134955

162

88

SEP 16 2016

Friday, September 16, 2016 9:04:27 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

Page 3

Friday, September 16, 2016 9:04:27 AM

Work Order ID: 151239

151239

Parent Item: D206-642-257

D206-642-257

Parent Item Name: Standard Wearplates, High Gear 206A/B Fits LH or RH

Start Date: 9/16/2016

Required Date: 9/21/2016

Start Qty: 2.00

Required Qty: 2.00

NAS1149C0332R

Purchased

No

Each

3,720.000

88

NAS1149C0332R

WASHER

Handwritten signature and checkmark

Location

Loc Qty

Loc Code

FP001

1162

m135274

1162

GA

131

m133284

131

ST260a

2000

m135408

1000

m135466

1000

ST266

427

m134736

427

SEP 16 2016

Handwritten: DAS 27 9-20

Handwritten: 88

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Work Order ID 151239

Friday, September 16, 2016 9:04:27 AM

151239

Ship Sept 19

Page 1

Item ID: D206-642-257

Revision ID:

Accept

N900040100

Setup Start

NS1

Item Name: Standard Wearplates, High Gear 206A/B Fits LH or RH

Start Date: 9/16/2016 Start Qty: 2.00

2

Required Date: 9/21/2016 Req'd Qty: 2.00

2

Cust Item ID:

Customer:

Stop

NS2

Approvals: Process Plan: Am

QC:

Date: 10/13/16

Tooling:

Date:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Draw Nbr
IIN D206-642

Revision Nbr
Q

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

100

Document Control

SEP 16 2016

0.00

100

DC

Doc. Control -USB or Paperwork

Memo

Photocopy bluefile & type labels per PPP D206-642-257
CHG001

0.00

DAS
21
9-89

SEP 16 2016

110

Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Quality Control

Memo

0.00

4.3 206A/B HIGH GEAR SKIDTUBES

ITEM	QTY -211	QTY -212	QTY -213	QTY -214	QTY -241	QTY -257	PART NUMBER	DESCRIPTION
	X						D206-642-211	SKIDTUBE INSTALLATION, LH
		X					D206-642-212	SKIDTUBE INSTALLATION, RH
			X				D206-642-213	SKIDTUBE INSTALLATION, LH, THRU BOLT
				X			D206-642-214	SKIDTUBE INSTALLATION, RH, THRU BOLT
	1	1	1	1	X		D206-642-241	SKIDTUBE
						X	D206-642-257	WEARSHOE KIT (REPLACES -247)
	1	1	1	1			D206-651-041	* 206 GHW ADAPTER ⁽¹⁾
1					1		D2650-3	SKIDTUBE ASSEMBLY
2A					18		D2651-1	* PLUG ⁽¹⁾
2B					18		D2651-3	* O-RING ⁽¹⁾
3					1		D2646	* AFT CAP ⁽¹⁾
4					2		MS27039-1-08	* SCREW ⁽¹⁾
5					2		NAS1149D0332J	* WASHER ⁽¹⁾ (OR AN960JD10L)
6	1		1				D2665-1	SADDLE, FWD OUT, LH
6		1		1			D2665-2	SADDLE, FWD OUT, RH
7	1		1				D2666-1	SADDLE, FWD IN, LH
7		1		1			D2666-2	SADDLE, FWD IN, RH
8	1						D2665-1	SADDLE, AFT OUT, LH
8		1					D2665-2	SADDLE, AFT OUT, RH
8			1				D2667-1	SADDLE, AFT OUT, LH
8				1			D2667-2	SADDLE, AFT OUT, RH
9	1						D2666-1	SADDLE, AFT IN, LH
9		1					D2666-2	SADDLE, AFT IN, RH
9			1				D2668-1	SADDLE, AFT IN, LH
9				1			D2668-2	SADDLE, AFT IN, RH
10	8	8	8	8			AN3-41A	BOLT
11	16	16	16	16			D2652	BUSHING
12A	8	8	8	8			MS21042-3	NUT (OR MS21042L3)
12B	8	8	8	8			NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4	4	4			AN5-7A	BOLT
14	4	4	4	4			AN5-11A	BOLT
14A			2	2			AN5-32A	* BOLT ⁽²⁾
14B			2	2			MS21042-5	* NUT (OR MS21042L5) ⁽²⁾
15	8	8	8	8			NAS1149D0563J	WASHER (OR AN960JD516)
16	12	12	12	12			AN4-6A	BOLT
17	24	24	24	24			NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12			MS21042-4	NUT (OR MS21042L4)
20A					4	4	D3537-1	WEARPAD (REPLACES D2648-3)
21A					1	1	D3537-3	WEARPAD (REPLACES D3429-1)
22A					1	1	D4956-13	WEARSHOE (REPLACES D3535-13 + D3536-13)
23A					1	1	D4956-21	WEARSHOE (REPLACES D3535-21 + D3536-21)
24A					1	1	D4956-33	WEARSHOE (REPLACES D3535-33 + D3536-33)
26A					44	44	MS27039C1-08	SCREW
26B					44	44	NAS1149C0332R	WASHER (OR AN960C10L)
26C					44		ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
28	2	2	2	2			AN6-44A	BOLT
29A	2	2	2	2			MS21042-6	NUT (OR MS21042L6)
29B	4	4	4	4			NAS1149D0663J	WASHER (OR AN960JD616)
	1	1	1	1			AN4C5A	BOLT
	1	1	1	1			NAS1149C0463R	WASHER (OR AN960C416)
	1	1	1	1			D3413-1	RING (REPLACES D2655)
	10	10	5	5			D2712	SET SCREW
	2	2	2	2			D2884	SADDLE SPACER
	2	2	2	2			D2885	SADDLE SPACER

(1) DENOTES THAT PART IS INCLUDED WITH D2650-3 ASSEMBLY ABOVE

(2) MAY BE REQUIRED ON -213/-214 INSTALLATIONS

(3) NOT INSTALLED AS PART OF SKIDTUBE. USED TO MODIFY OEM GROUND HANDLING WHEELS

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Revision: Q

Date: 13.08.12